

Date: Wednesday, 16/01/2008 9:56:33 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 36733	
Estimate Number : 10688	
P.O. Number :	Part Number : D3162041
This Issue : 16/01/2008 S.O. No. :	Drawing Number : D3162 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 36733	Material :
Written By :	Due Date : 02/10/2008
Checked & Approved By :	Qty: 12 Um: Each
Comment : Est A 02.05.14 New Issue NG Est Rev:B 08-01-15 now on water jet DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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1.748



Comment: Qty.: 0.0076 sf(s)/Unit Total : 0.0907 sf(s)

6061-T6 .063 Sheet

Matl: 6061-T6 .063" thick (M6061T6S.063)

105225 HB 8-1-18

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3162

Dwg Rev: C

Prog Rev: C

HB 8-1-18

23

2-Deburr if necessary

08/01/23 23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-1-18

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/01/24 23

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges .005 to 0.010

Form as per drawing

C'sink holes as per Dwg D3162

08/01/25 23

MVF 08-01-25

9

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/10/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/01/2008 9:56:33 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 36733

Part Number: D3162041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JP 08-01-28

(X9)

7.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut Plate

Pick:

Qty	Part Number	Description	Batch
1	MS21059L3	Nutplate	M103698

JP 08/01/29

8.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-4	Rivet	M102404

JP 08/01/29

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per drawing

JP 08/01/29 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 08/01/29 (X5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 74

JP 08/01/30 (9)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JP 08/01/31

Job Completion



JP 08/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

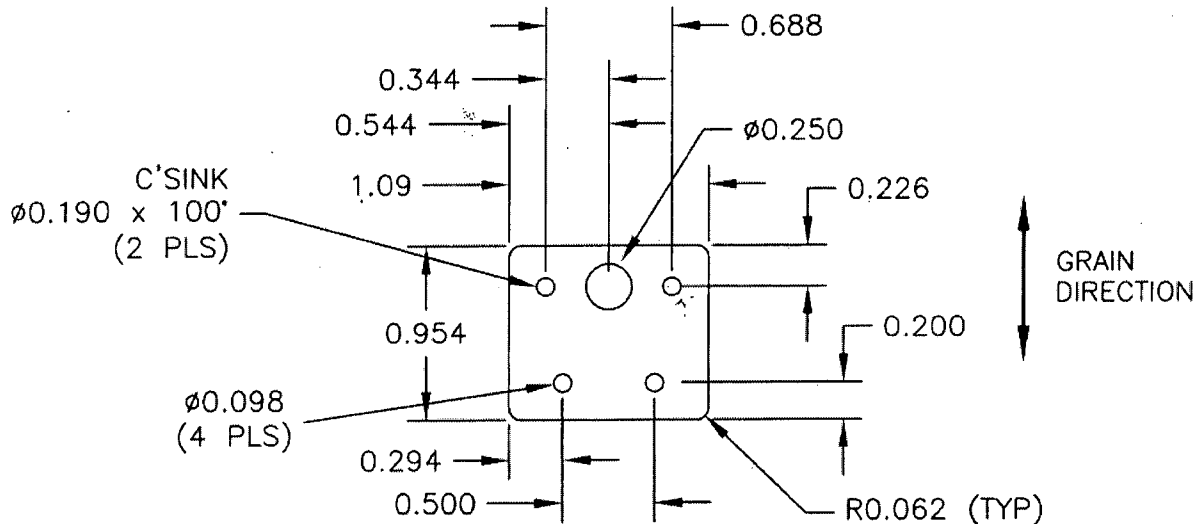
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

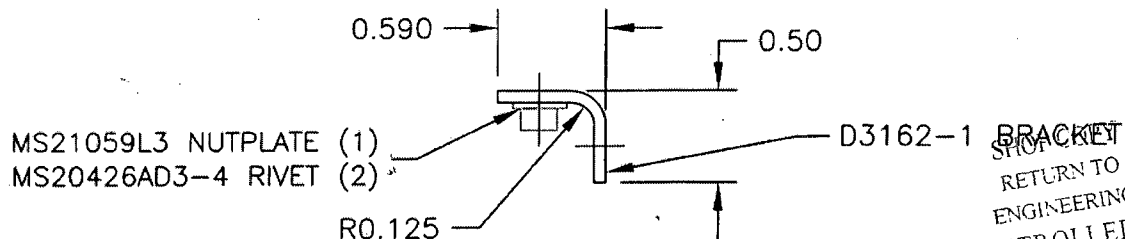
NOTE: Date & initial all entries

DART**RELEASED**
05.12.01

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	



D3162-1F FLAT PATTERN
(USED TO MAKE D3162-1 BRACKET)



D3162-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

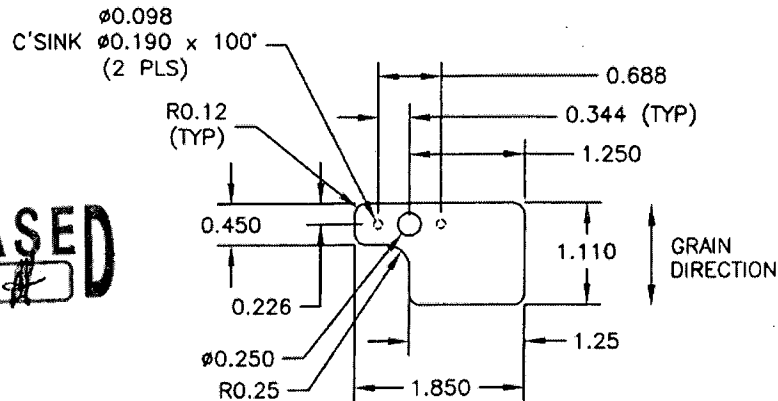
BRACKET
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36733

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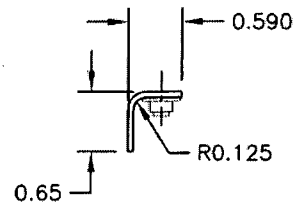
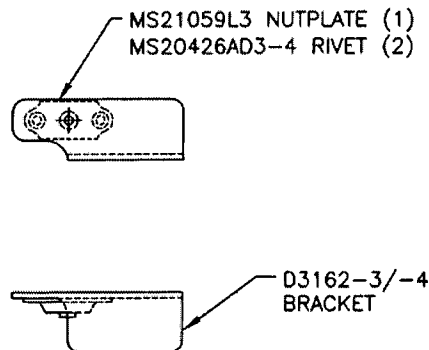
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DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
05.12.01

D3162-3F FLAT PATTERN
(USED TO MAKE D3162-3/-4 BRACKETS)



D3162-043 BRACKET ASSEMBLY (SHOWN).
(D3162-044 BRACKET ASSEMBLY (OPPOSITE))

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36733

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order:	36733
Description: BRACKET ASSEMBLY		Part Number:	D3162-041
Inspection Dwg: D3162 Rev: C			Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by:	B
Date:	8-1-18

Audited by:	
Date:	06/01/18

Prototype Approval:	
Date:	1/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	